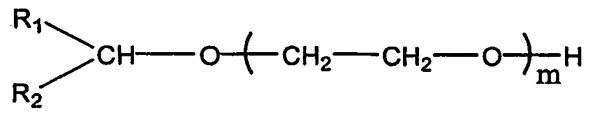
**THE CLAIMS DEFINING THE INVENTION ARE AS FOLLOWS:**

1. A compound of the formula (I):

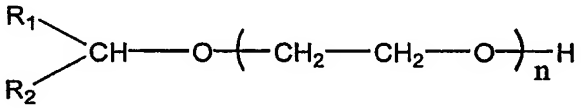


(I)

wherein $R_1$ and $R_2$ are each independently $C_1$-$C_4$ alkyl, and
m is 1, 2, 3, 4, or 5.

2. A compound according to claim 1, wherein the group $R_1R_2CH$- is 4-methyl-pent-2-yl.

3. A composition comprising at least two compounds of formula (II):



(II)

wherein $R_1$ and $R_2$ are each independently $C_1$-$C_4$ alkyl, and n is an integer $\geq 0$ and wherein the average molar value of n for the total of the compounds of formula (II) in said composition is in the range of 1 to 3.

4. A composition according to claim 3 wherein the average molar value of n is in the range of 1 to 2.

5. A composition according to claim 4 wherein the average molar value of n is about 1.7.

6. A composition according to claim 3 or claim 4 wherein $R_1R_2CH$- is 4-methyl-pent-2-yl.

7. A composition according to any one of claims 3 to 6, wherein the compound of formula (II) where n=0 comprises less than 15% by weight of the total composition.

8. A composition according to claim 7, wherein the compound of formula (II) where n=0 comprises less than 10% by weight of the total composition.

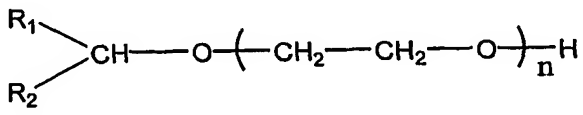
9. A composition according to claim 7 or claim 8, wherein the compound of formula (I) where n=0 comprises less than or equal to 6.5% by weight of the total composition.

10. A composition according to any one of claims 3 to 9, wherein the total combined weight of compounds where n=0 and n=1 is such that the closed-cup flash point of said composition is greater than 65°C.

11. A composition according to any one of claims 3 to 10, wherein the total weight of compounds of formula (I) where n is greater than 4 is less than 20% of the combined total of compounds of formula (I).

12. A composition according to any one of claims 3 to 11 which further comprises other additives.

13. A method of preparing a composition comprising at least two compounds of formula (II):



(II)

wherein $R_1$ and $R_2$ are each independently $C_1$-$C_4$ alkyl, and n is an integer $\geq 0$, and wherein the average molar value of n for the total of the compounds of formula (II) in said composition is in the range of 1 to 3, said method comprising;

reacting an excess of $C_3$–$C_9$ secondary alcohol with ethylene oxide in the presence

of a catalyst in an ethoxylation vessel to form a mixture of two or more compounds of formula (II), separating at least a portion of unreacted secondary alcohol from the mixture recycling the unreacted secondary alcohol back to the ethoxylation vessel.

14. A method according to claim 13, wherein the $C_3$-$C_9$ secondary alcohol is 4-methyl-2-pentanol.

15. A method according to claim 13 or claim 14 wherein the unreacted secondary alcohol is removed by distillation to provide a composition comprising unreacted secondary alcohol in an amount of less than 15% by weight of the total composition.

16. A method according to claim 15, wherein unreacted secondary alcohol comprises less than 10% by weight of the total composition.

17. A method according to claim 15 or claim 16, wherein the unreacted secondary alcohol comprises less than or equal to 8% by weight of the total composition.

18. A method according to claim 13 comprising a distillation step to remove from the composition compounds of formula (II) wherein n=0 and n=1 such that the closed-cup flash point of said composition is greater than 65°C.

19. A method according to any one of claims 14 to 17 wherein total weight of compounds of formula (II) where n is greater than 4 in said composition is less than 20% of the combined total of the compounds of formula (II) in the composition.

20. A method according to any one of claims 13 to 18, wherein the ethylene oxide to $C_3$-$C_9$ secondary alcohol ratio is kept below 70 wt% in said ethoxylation vessel.

21. A method according to claim 20, wherein the ratio is kept below 10 wt%.

22. A method according to any one of claims 13 to 20, wherein the catalyst is an alkali

metal or alkaline earth metal base catalyst or a Lewis or Bronsted acid catalyst.

23. A method according to any one of claims 13 to 21, wherein the catalyst is a Narrow Range Ethoxylation catalyst.

24. A method according to claim 22, wherein the alkali metal catalyst is potassium hydroxide.

25. A method of preparing a compound of formula (I) according to claim 1, comprising reacting a $C_3$-$C_9$ secondary alcohol with ethylene oxide in the presence of a catalyst, and isolating the compounds from the reaction mixture by distillation.

26. Use of a composition according to any one of claims 3 to 12 in the recovery of clean coal in a froth flotation process.

27. Use of a composition according to claim 26, wherein the froth flotation process is performed in a Microcel®.

28. Use of a composition according to claim 26, wherein the froth flotation process is performed in a Jameson® cell.

29. Use of a composition according to claim 26 wherein the froth flotation process is performed in an EKOF® cell.

30. Use of a composition according to any one of claims 3 to 12 to lower surface tension and to improve the performance of dissolved air flotation.

31. Use of a composition according to any one of claims 3 to 12 in the recovery and concentration of desirable minerals or selective removal of undesirable minerals by flotation.

32. Use of a composition according to any one of claims 3 to 12 in the recovery of sulphide minerals by flotation.

33. Use of a composition according to any one of claims 3 to 12 for refining mineral or coal by froth flotation.

34. Use of a composition according to any one of claims 3 to 12 as a solvent/co-solvent for formulation of dyes, oils, resins and other industrial products.

35. Use of a composition according to any one of claims 3 to 12 for coupling of polar organic compounds with hydrocarbon liquids.

36. Use of a composition according to any one of claims 3 to 12 as a diluent for hydraulic fluids.